

Work Order ID 46413

June 29, 2009 10:26:13 AM



Page 1

Item ID: D6101-013

Accept



Setup Start



Revision ID: A

Stop



Item Name: Saddle Billet

Start Date: 17/07/2009 Start Qty: 50.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D6101

Rev A

0.00

0.00

100



Purchasing

PURCHASING

Memo

Issue P/O: 8893 : a) Description: Alluminum billet : b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000) : c) Tolerance on all dimensions are +0.030"/-0.000" : d) Grain direction along 10.100" length : e) Material: 7075-T7351 (QQ-A-250/12) : f) Material

CZ 09/10/23

110



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure material certification is attached

P 09/14/06 (10)

120



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

09/11/09

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June 29, 2009 10:26:13 AM



Page 2

Item ID: D6101-013

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Setup Start



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Item Name: Saddle Billet

Stop



Start Date: 17/07/2009 Start Qty: 50.00



Cust Item ID:

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: MAT

0.00



*mf* 09/11/09

10

Packaging

Memo

0.00

Packaging

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/10 *[Signature]*  
*mf* 09-11-10

# Picklist Print

June 29, 2009 10:26:12 AM

Page 1

Work Order ID: 46413

Parent Item: D6101-013RevA

Parent Item Name: Saddle Billet




Comments:

Start Date: 17/07/2009

Required Date: 03/08/2009

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-013PRevA		Purchased	No			110	Each	10.0000	50.0000			
												
Saddle billet												

*Peg/4/6* (10)

**Castle Metals®**

A. M. Castle &amp; Co.

**PACKING SLIP**

Page 1 of 1

Pack Slip No:6220298

<b>Ship From:</b> Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b> 05-NOV-09	<b>F.O.B.</b> ORIGIN	<b>Freight Terms</b> Prepaid		<b>Carrier</b> MANITOULIN	<b>BOL No</b> 114842-2	<b>Delivery No</b> 6220298	

<b>Shipment Details</b>	<b>Final Destination Branch - MON</b>
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<b>Order No</b> 369846	<b>Line No</b> 3	<b>Item No</b> 6879.MO	<b>Description</b> 2.5000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 8.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 10.1")) X 10.1 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 10.1")) - ALUMINUM PLATE SAW			
<b>Purchase Order No</b> 8393		<b>Part Number</b>	<b>Ordered Qty</b> 10 PCS	<b>Invoice Qty</b> 10 PCS	<b>Backorder Qty</b>	
<b>Details</b>						
<b>Mill</b>	<b>Heat Number</b> 422799A7	<b>Mech Id</b>	<b>PCS</b> 10	<b>Width (IN)</b>	<b>Length (IN)</b>	<b>Shipped Qty (LBS)</b> 210.43

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.	
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.	
This material has been received and inspected by:	Date:

*amf*  
09/11/09

**KAISER  
ALUMINUM****CERTIFIED TEST REPORT**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

Serial Number  
4128061

\* Lot: 422799A7 Cast 161 Drop 29 Ingot 2

(ASTM B8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.2 : 72.5 (484 : 500)	58.1 : 61.4 (401 : 423)	9.8 : 10.0

(ASTM E1004)

Conductivity %IACS :	40.5 Min	40.9 Max
(MS/M) :	23.5 Min	23.7 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.20	1.5	0.02	2.7	0.19	5.7	0.02	0.01	0.01	TOT 0.03

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

**TEST NOTES**

Metal represented by this test report was immersion  
ultrasonically tested from one side and meets the Class A  
and Class B requirements of all specifications referenced  
on this test report.

*Handwritten signature*  
08/11/09

<b>CASTLE METALS - KENT</b>	
DATE REC'D <u>5-2-08</u>	CUST. _____
REC'D FROM <u>KATIE</u>	CUST. P.O. _____
APPROVED BY <u>AM</u>	AMC S/O _____
TR # <u>422799A1/422799A7</u>	
WE HEREBY CERTIFY THAT THESE ARE CORRECT COPIES OF REPORTS NOW ON FILE AT A.M. CASTLE & CO. BY: <u>Joe 6879</u>	

**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

**BILL POYNOR, LABORATORIES SUPERVISOR**

*Handwritten signature of Bill Poynor*

SHIP TO:

CASTLE METALS  
C/O CUTTER PRECISION METALS  
1208 NO. 4TH AVE  
KENT, WA 98032

SOLD TO:

AM CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

**CERTIFIED TEST REPORT**

Serial Number

4128061

CUSTOMER PO NUMBER: 45-24870		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-80		SHIP RUN/LOAD ID: 101272/3		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1066098	LINE ITEM: 1	SHIP DATE: 28-APR-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 7214 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 2017533		GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

**Certified Specifications**

AMS 4078/RevG  
ASTM B 209/Rev07  
BSS 7055/RevA  
DPS 4.713/RevAH  
GSS16100/RevG

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevR  
EAC MS1011/RevE  
MMS 159/RevN

AMS-STD-2154  
BAC 5439/RevH  
CSTI 006/RevC  
GAMPS 9101/RevB  
PS 21211/RevK

Test Code: 4297

**Test Results**

Lot: 422797A1 Cast 161

Drop 21

Ingot 2

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.8 : 71.0 (488 : 490)	60.2 : 60.8 (415 : 418)	9.7 : 10.4

(ASTM E1004)

Conductivity %IACS :	41.4 Min	41.6 Max
(MS/M) :	24.0 Min	24.1 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.22	1.5	0.02	2.4	0.19	5.6	0.02	0.01	0.01	TOT 0.03